

# CONTENTS

Foreword .....	vii
Statements of Policy .....	viii
Committee Roster .....	ix
Summary of Changes .....	xii
<b>Part GR General Requirements</b>	
GR-1 Introduction .....	1
GR-2 Scope .....	1
GR-3 Inspection .....	1
GR-4 Inspector/Examiner .....	1
GR-5 Responsibilities .....	1
GR-6 Access for Inspectors .....	2
GR-7 Manufacturer’s Quality Assurance Program .....	2
GR-8 Metric .....	2
GR-9 References .....	2
GR-10 Terms and Definitions .....	3
<b>Part SD Design for Sterility and Cleanability</b>	
SD-1 Introduction .....	8
SD-2 Scope and Purpose .....	8
SD-3 General Guidelines .....	8
SD-4 Specific Guidelines .....	19
SD-5 Testing and Inspection .....	44
SD-6 Documentation .....	46
SD-7 Responsibilities .....	46
<b>Part DT Dimensions and Tolerances for Stainless Steel Automatic Welding and Hygienic Clamp Tube Fittings and Process Components</b>	
DT-1 Scope .....	47
DT-2 Pressure Rating .....	47
DT-3 Marking .....	47
DT-4 Materials .....	47
DT-5 Metal Thickness .....	47
DT-6 Fitting Dimensions .....	47
DT-7 Tests .....	48
DT-8 Tolerances .....	48
DT-9 Welding Ends .....	48
DT-10 Hygienic Clamp Ends .....	48
DT-11 Heat Treatment .....	48
DT-12 Surface Condition .....	48
DT-13 Packaging .....	48
DT-14 Minimum Examination Requirements .....	48
<b>Part MJ Material Joining</b>	
MJ-1 Scope .....	66
MJ-2 Materials .....	66
MJ-3 Joining Processes and Procedures .....	66
MJ-4 Weld Joint Design and Preparation .....	67
MJ-5 Filler Material .....	67
MJ-6 Weld Acceptance Criteria .....	67
MJ-7 Inspection, Examination, and Testing .....	69
MJ-8 Procedure Qualification .....	73

MJ-9	Performance Qualification .....	73
MJ-10	Documentation Requirements .....	73
MJ-11	Passivation .....	74
<b>Part SF</b>	<b>Stainless Steel and Higher Alloy Product Contact Surface Finishes</b>	
SF-1	Scope .....	75
SF-2	Objective .....	75
SF-3	Applications .....	75
SF-4	Material .....	75
SF-7	Inspection and Techniques Employed in the Classification of Product Contact Surface Finishes .....	75
SF-8	Description of Various Surfaces Available on Stainless Steel and Higher Alloys .....	75
<b>Part SG</b>	<b>Equipment Seals</b>	
SG-1	Scope and Purpose .....	82
SG-2	Seal Classes .....	82
SG-3	General Provisions for Seals in Bioprocessing Service: User Basic Design Requirement .....	82
SG-4	Special Provisions for Seals in Bioprocessing Service .....	89
<b>Part PM</b>	<b>Polymer-Based Materials</b> .....	95
PM-1	Introduction .....	95
PM-2	Design Considerations for Polymeric Piping, Tubing, Fittings, Valve Bodies, and Other Components .....	95
PM-3	Polymer Material Joining .....	97
PM-4	Polymer Interior Product Contact Surfaces of Piping, Tubing, Fittings, Valve Bodies, and Coated or Lined Vessels .....	101
PM-5	Materials of Construction .....	101
<b>Figures</b>		
SD-1	Hygienic Connections .....	10
SD-2	Non-Hygienic Connections .....	12
SD-3	Flat Gasket Applications .....	13
SD-4	Recommended and Preferred Drop Designs .....	17
SD-5	Double Block-and-Bleed Valve Assembly .....	18
SD-6	Instrument Location Detail: Hygienic Design .....	19
SD-7	Flexible Hygienic Hose Design .....	20
SD-8	Tank/Vessel Vent Filters .....	22
SD-9	Nozzle Design .....	24
SD-10	Sidewall Instrument Ports .....	25
SD-11	Dip Tube .....	26
SD-12	Vessel Design Tangential Nozzles .....	26
SD-13	Vessel Sight Glass Design .....	27
SD-14	Side and Bottom Connections .....	28
SD-15	Dip Tube Nozzles: Removable Designs .....	29
SD-16	Sight Glass Design .....	30
SD-17	Internal Support Members .....	31
SD-18	Mitered Fittings .....	32
SD-19	Typical Nozzle Detail .....	32
SD-20	Double Tubesheet Heat Exchanger Bonnet Design .....	33
SD-21	In-Tank Couplings .....	34
SD-22	Removable Agitator Impeller Design .....	36
SD-23	Point-of-Use Piping .....	38
SD-24	Transfer Panel Tolerances .....	42
SD-25	Transfer Panel Looped Headers .....	43
SD-26	Transfer Panel Jumpers .....	45
MJ-1	Acceptable and Unacceptable Weld Profiles for Tube Welds .....	71
SG-1	Basic Components of a Seal .....	85

SG-2	Single Dry Running Contacting Seal .....	86
SG-3	Internally Mounted, Process Lubricated Contact Seal .....	86
SG-4	Externally Mounted, Process Lubricated Contact Seal .....	87
SG-5	Double Seal Installation .....	87
SG-6	Tandem Seal Installation .....	88
SG-7	Seal Piping and Lubrication Plans .....	89
SG-8	Gas Lubricated Noncontacting Double Seal .....	90
SG-9	Tandem Seal With Barrier System .....	90
SG-10	Typical Packing Installation .....	91
SG-11	V-Ring Packing for Reciprocating Applications .....	91
SG-12	Open Cross-Sectional Lip Seal .....	91
SG-13	Labyrinth Seal .....	91
SG-14	Typical Angle Valve With Rolling Diaphragm and Orifice .....	92
SG-15	Example of Sampling Valve With Uniformly Loaded Sliding Seal .....	93
SG-16	Typical In-Line Diaphragm Valve With Weir .....	93
SG-17	Typical Ball Valve Configuration .....	94
PM-1	Acceptable and Unacceptable Weld Profiles for Beadless Welds .....	100
<b>Tables</b>		
SD-1	L/D Dimensions for Flow-Through Tee: Full-Size Standard Straight Tee With Blind Cap .....	14
SD-2	L/D Dimensions for Flow-Through Tee: Short Outlet Reducing Tee With Blind Cap .....	15
SD-3	Annular Spacing Recommendations for Hygienic Dip Tubes .....	25
SD-4	Recommended Flow Rates to Achieve 5 fps (1.52 mps) .....	40
SD-5	Recommended Flow Rates for Cleaning Vertical Cylindrical Vessels Having Dished Heads .....	40
SD-6	Transfer Panel and Jumper Tolerances .....	44
DT-1	Nominal OD Tubing Sizes .....	50
DT-2	Hygienic Unions .....	51
DT-3	Chemical Composition for Automatic Weld Ends, % .....	51
DT-4	Tangent Lengths .....	51
DT-5	Final Tolerances for Mechanically Polished Fittings and Process Components .....	52
DT-5.1	Hygienic Clamp Ferrule Standard Dimensions and Tolerances .....	53
DT-6	Final Tolerances for Electropolished Fittings and Process Components .....	54
DT-7	Automatic Tube Weld: 90 deg Elbow .....	54
DT-8	Automatic Tube Weld: 45 deg Elbow .....	54
DT-9	Automatic Tube Weld: Straight Tee and Cross .....	55
DT-10	Automatic Tube Weld: Reducing Tee .....	55
DT-11	Automatic Tube Weld: Concentric and Eccentric Reducer .....	56
DT-12	Automatic Tube Weld: Hygienic Clamp Joint, 90 deg Elbow .....	56
DT-13	Automatic Tube Weld: Hygienic Clamp Joint, 45 deg Elbow .....	57
DT-14	Automatic Tube Weld: Short Outlet Hygienic Clamp Joint Reducing Tee .....	57
DT-15	Automatic Tube Weld: Short Outlet Hygienic Clamp Joint Tee .....	58
DT-16	Hygienic Clamp Joint: 90 deg Elbow .....	58
DT-17	Hygienic Clamp Joint: 45 deg Elbow .....	59
DT-18	Hygienic Clamp Joint: Straight Tee and Cross .....	59
DT-19	Hygienic Clamp Joint: Reducing Tee .....	60
DT-20	Hygienic Clamp Joint: Short Outlet Reducing Tee .....	60
DT-21	Hygienic Clamp Joint: Concentric and Eccentric Reducer .....	61
DT-22	Automatic Tube Weld: Ferrule .....	62
DT-23	Automatic Tube Weld: 180 deg Return Bend .....	63
DT-24	Hygienic Clamp Joint: 180 deg Return Bend .....	63
DT-25	Hygienic Mechanical Joint: Short Outlet Run Tee .....	64
DT-26	Hygienic Clamp Joint: Tube Weld Concentric and Eccentric Reducer .....	64

DT-27	Hygienic Clamp Joint: Short Outlet Tee .....	65
DT-28	Automatic Tube Weld: Instrument Tee .....	65
DT-29	Hygienic Clamp Joint: Instrument Tee .....	65
DT-30	Automatic Tube Weld: Cap .....	65
MJ-1	Acceptance Criteria for Welds on Pressure Vessels and Tanks .....	68
MJ-2	Acceptance Criteria for Welds on Pipe .....	69
MJ-3	Acceptance Criteria for Welds on Tube .....	70
SF-1	Acceptance Criteria for Product Contact Surface Finishes of Tubing .....	77
SF-2	$R_a$ Readings for Tubing .....	77
SF-3	Acceptance Criteria for Product Contact Surface Finishes of Fittings .....	78
SF-4	$R_a$ Readings for Fittings .....	78
SF-5	Acceptance Criteria for Product Contact Surface Finishes of Valve Bodies .....	79
SF-6	$R_a$ Readings for Valves .....	79
SF-7	Acceptance Criteria for Product Contact Surface Finishes of Vessels .....	80
SF-8	$R_a$ Readings for Vessels .....	80
SF-9	Acceptance Criteria for Product Contact Surface Finishes of Other Process Components .....	81
SF-10	$R_a$ Readings for Other Process Components .....	81
SG-1	Common Rotary Seal Materials for Biochemical and Sterile Service .....	88
PM-1	Size Comparison of Common Thermoplastic Sizing Standards .....	96
<b>Nonmandatory Appendices</b>		
A	Commentary: Slag .....	103
B	Material Examination Log and Weld Log .....	104
<b>Index</b>	.....	109